

Date: Thursday, 17/04/2008 10:59:18 AM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)  
 Job Number : 38658  
 Estimate Number : 10534  
 P.O. Number :  
 This Issue : 17/04/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D2574  
 Drawing Number : D2574 REV E  
 Project Number : N/A  
 Drawing Revision : E  
 First Issue : / / Type : MACHINED PARTS  
 Material :  
 Due Date : 01/05/2008 Qty: 8 Um: Each  
 Previous Run : 37924  
 Written By :  
 Checked & Approved By : JLD 08.4.17  
 Comment : Est Rev: I As Per RevE 06-01-27 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101005 Saddle Billet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2574

Ensure that grain is along 5.00" length

Batch No: B34874

DIP 08/05/20

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 38658 Double check by: \_\_\_\_\_

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

88 08/05/23

DIP 08/05/21

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

88 08/05/23

DIP 08/05/21

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP 08/05/21

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 17/04/2008 10:59:18 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 38658

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 08/05/28

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M. J. / RB 08/05/28

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3.5.1

M 107892

start: 11:55  
Temp: 320°  
End: 12:25

FZ 08/05/28

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M. J.

08/05/28

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST. 08/05/28

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/29

Job Completion



MF 08-05-29

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|   |                           |
|---|---------------------------|
| <b>DART AEROSPACE LTD</b>               | <b>Work Order:</b> 38658  |
| <b>Description:</b> Saddle, Aft Inboard | <b>Part Number:</b> D2574 |
| <b>Inspection Dwg:</b> D2574 Rev. E     | <b>Page 1 of 1</b>        |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

| Dim           | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |       |       |       | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
|               |       |       |                | 1                          | 2     | 3     | 4     |    |      |
| A             | 0.438 | 0.443 |                | .441                       | .441  | .442  | 0.443 |    |      |
| B             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.748 |    |      |
| C             | 3.495 | 3.505 |                | 3.500                      | 3.500 | 3.500 | 3.497 |    |      |
| D             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.749 |    |      |
| E             | 7.990 | 8.010 |                | 8.002                      | 8.000 | 8.001 | 7.998 |    |      |
| F             | 0.490 | 0.510 |                | .505                       | .500  | .495  | 0.495 |    |      |
| G             | 0.257 | 0.262 |                | 0.259                      | 0.259 | .258  | .258  |    |      |
| H             | 0.375 | 0.380 |                | 0.378                      | 0.378 | .378  | .378  |    |      |
| I             | 0.490 | 0.510 |                | .502                       | .500  | .501  | .501  |    |      |
| J             | 1.174 | 1.184 |                | 1.179                      | 1.179 | 1.179 | 1.179 |    |      |
| K             | 0.558 | 0.578 |                | .570                       | .570  | .570  | .570  |    |      |
| L             | 1.174 | 1.184 |                | 1.179                      | 1.179 | 1.179 | 1.179 |    |      |
| M             | 1.365 | 1.375 |                | 1.370                      | 1.370 | 1.370 | 1.370 |    |      |
| N             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500 |    |      |
| O             | 4.119 | 4.129 |                | 4.124                      | 4.124 | 4.124 | 4.124 |    |      |
| P             | 0.115 | 0.135 |                | 0.126                      | 0.126 | .126  | .126  |    |      |
| Q             | 0.115 | 0.135 |                | .135                       | .135  | .135  | .135  |    |      |
| R             | 0.240 | 0.260 |                | 0.247                      | 0.247 | .250  | .250  |    |      |
| S             | 0.115 | 0.135 |                | .128                       | .123  | .131  | .125  |    |      |
| T             | 0.178 | 0.198 |                | 0.188                      | 0.188 | .188  | .188  |    |      |
| U             | 3.210 | 3.250 |                | 3.230                      | 3.230 | 3.230 | 3.230 |    |      |
| V             | 0.230 | 0.250 |                | .235                       | .236  | .235  | .234  |    |      |
| W             | 0.115 | 0.135 |                | .134                       | .135  | .130  | 0.132 |    |      |
| X             | 0.307 | 0.312 |                | .310                       | .310  | .310  | .310  |    |      |
| Y             | 0.760 | 0.765 |                | .760                       | .760  | .760  | .760  |    |      |
| Z             | 0.352 | 0.372 |                | .367                       | .367  | .363  | 0.362 |    |      |
| AA            | 0.470 | 0.530 |                | 0.500                      | 0.500 | .500  | .500  |    |      |
| AB            | 0.615 | 0.635 |                | .625                       | .625  | .625  | 0.626 |    |      |
| AC            | 0.053 | 0.073 |                | .063                       | .063  | .063  | 0.063 |    |      |
| AD            | 0.240 | 0.260 |                | .250                       | .250  | .250  | .250  |    |      |
| AE            | 1.500 | 1.520 |                | 1.510                      | 1.511 | 1.512 | 1.515 |    |      |
| AF            | 0.115 | 0.135 |                | .135                       | .135  | .135  | 0.135 |    |      |
| AG            | 0.240 | 0.280 |                | .260                       | .260  | .260  | .260  |    |      |
| AH            | 0.240 | 0.260 |                | .245                       | .245  | .245  | .245  |    |      |
| AI            | 2.000 | 2.020 |                | 2.000                      | 2.002 | 2.001 | 2.001 |    |      |
| AJ            | 0.023 | 0.043 |                | .033                       | .033  | .033  | .033  |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

|                |
|----------------|
| Measured by:   |
| Date: 08/05/21 |

|                |
|----------------|
| Audited by:    |
| Date: 08/05/28 |

| Rev | Date     | Change                                  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue                               | RF         |          |
| B   | 02.09.27 | Re-format; Added Rev. D                 | KJ         |          |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |          |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |          |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     |          |

|   |  |                           |
|---|--|---------------------------|
| <b>DART AEROSPACE LTD</b>               |  | <b>Work Order:</b> 38658  |
| <b>Description:</b> Saddle, Aft Inboard |  | <b>Part Number:</b> D2574 |
| <b>Inspection Dwg:</b> D2574 Rev. E     |  | <b>Page 1 of 1</b>        |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

| Dim           | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |        |       |        | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|-------|--------|----|------|
|               |       |       |                | 5                          | 6      | 7     | 8      |    |      |
| A             | 0.438 | 0.443 |                | 0.443                      | 0.443  | 0.443 | 0.443  |    |      |
| B             | 1.745 | 1.755 |                | 1.749                      | 1.750  | 1.748 | 1.749  |    |      |
| C             | 3.495 | 3.505 |                | 3.501                      | 3.500  | 3.499 | 3.500  |    |      |
| D             | 1.745 | 1.755 |                | 1.750                      | 1.750  | 1.749 | 1.750  |    |      |
| E             | 7.990 | 8.010 |                | 7.997                      | 7.998  | 7.997 | 7.997  |    |      |
| F             | 0.490 | 0.510 |                | 0.492                      | 0.4945 | 0.490 | 0.492  |    |      |
| G             | 0.257 | 0.262 |                | .258                       | .258   | .258  | 0.259  |    |      |
| H             | 0.375 | 0.380 |                | .377                       | .377   | .377  | 0.378  |    |      |
| I             | 0.490 | 0.510 |                | .500                       | 0.497  | 0.496 | 0.495  |    |      |
| J             | 1.174 | 1.184 |                | 1.180                      | 1.179  | 1.180 | 1.179  |    |      |
| K             | 0.558 | 0.578 |                | .570                       | 0.567  | 0.564 | 0.564  |    |      |
| L             | 1.174 | 1.184 |                | 1.180                      | 1.179  | 1.180 | 1.180  |    |      |
| M             | 1.365 | 1.375 |                | 1.370                      | 1.370  | 1.371 | 1.370  |    |      |
| N             | 2.495 | 2.505 |                | 2.501                      | 2.500  | 2.500 | 2.501  |    |      |
| O             | 4.119 | 4.129 |                | 4.124                      | 4.124  | 4.121 | 4.122  |    |      |
| P             | 0.115 | 0.135 |                | .125                       | .125   | .125  | 0.125  |    |      |
| Q             | 0.115 | 0.135 |                | .135                       | 0.135  | 0.135 | 0.135  |    |      |
| R             | 0.240 | 0.260 |                | .248                       | .248   | .248  | 0.248  |    |      |
| S             | 0.115 | 0.135 |                | .126                       | 0.126  | 0.127 | 0.126  |    |      |
| T             | 0.178 | 0.198 |                | .188                       | .188   | .188  | 0.188  |    |      |
| U             | 3.210 | 3.250 |                | 3.231                      | 3.230  | 3.231 | 3.230  |    |      |
| V             | 0.230 | 0.250 |                | .233                       | 0.230  | 0.231 | 0.230  |    |      |
| W             | 0.115 | 0.135 |                | 0.132                      | 0.132  | 0.132 | 0.133  |    |      |
| X             | 0.307 | 0.312 |                | 0.310                      | .310   | .310  | .310   |    |      |
| Y             | 0.760 | 0.765 |                | 0.760                      | 0.760  | 0.760 | 0.760  |    |      |
| Z             | 0.352 | 0.372 |                | 0.363                      | 0.365  | 0.365 | 0.365  |    |      |
| AA            | 0.470 | 0.530 |                | .500                       | .500   | .500  | 0.500  |    |      |
| AB            | 0.615 | 0.635 |                | 0.625                      | 0.628  | 0.628 | 0.625  |    |      |
| AC            | 0.053 | 0.073 |                | 0.063                      | 0.063  | 0.063 | 0.063  |    |      |
| AD            | 0.240 | 0.260 |                | .250                       | .249   | .250  | 0.244  |    |      |
| AE            | 1.500 | 1.520 |                | 1.513                      | 1.511  | 1.510 | 1.5105 |    |      |
| AF            | 0.115 | 0.135 |                | 0.135                      | 0.135  | 0.135 | 0.135  |    |      |
| AG            | 0.240 | 0.280 |                | .260                       | .260   | .260  | 0.260  |    |      |
| AH            | 0.240 | 0.260 |                | .245                       | 0.241  | 0.243 | 0.242  |    |      |
| AI            | 2.000 | 2.020 |                | 2.002                      | 2.003  | 2.002 | 2.002  |    |      |
| AJ            | 0.023 | 0.043 |                | 0.033                      |        |       |        |    |      |
| Accept/Reject |       |       |                |                            |        |       |        |    |      |

|              |          |
|--------------|----------|
| Measured by: | D.F.     |
| Date:        | 08/05/28 |

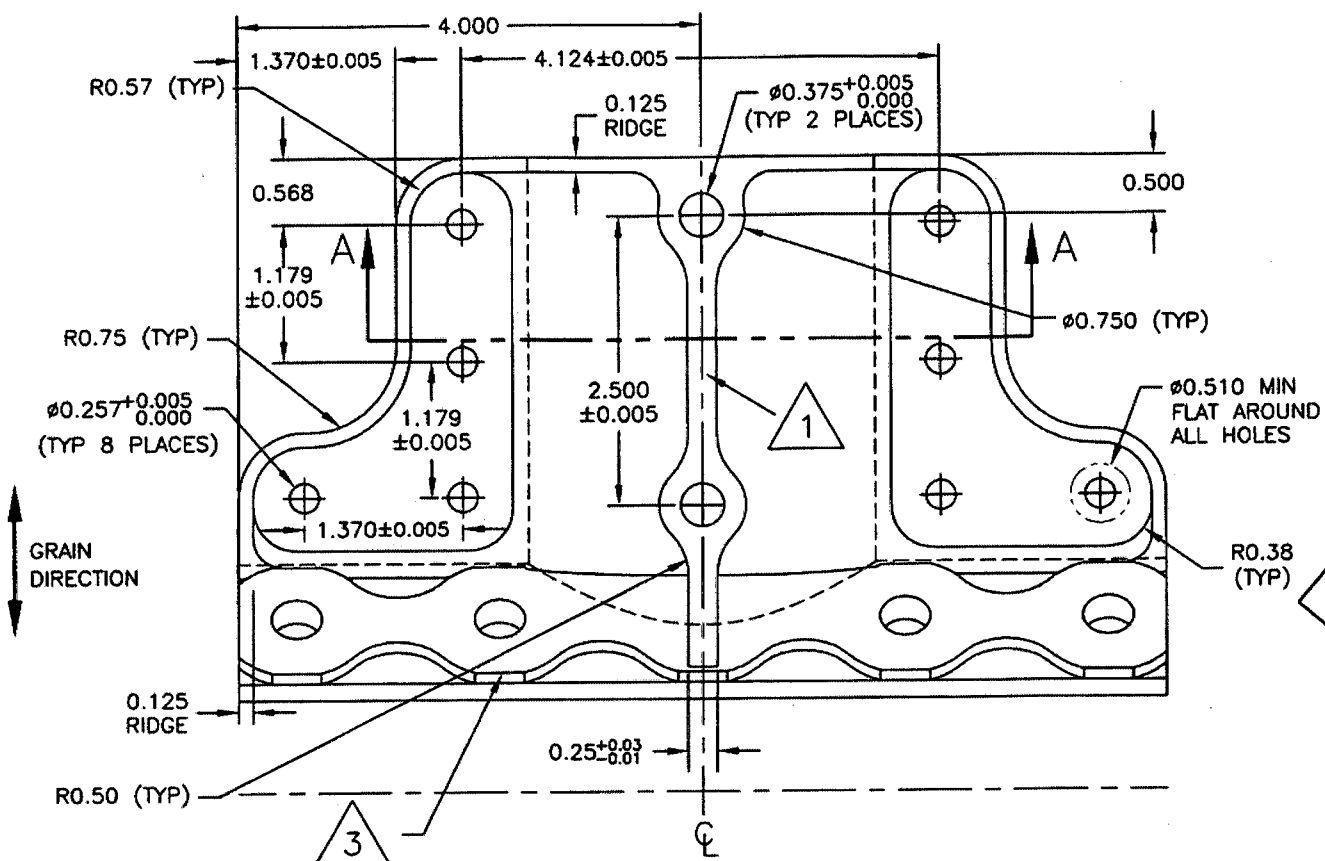
|             |          |
|-------------|----------|
| Audited by: | SD       |
| Date:       | 08/05/28 |

| Rev | Date     | Change                                  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue                               | RF         |          |
| B   | 02.09.27 | Re-format; Added Rev. D                 | KJ         |          |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |          |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |          |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     |          |



RELEASED

05.12.06

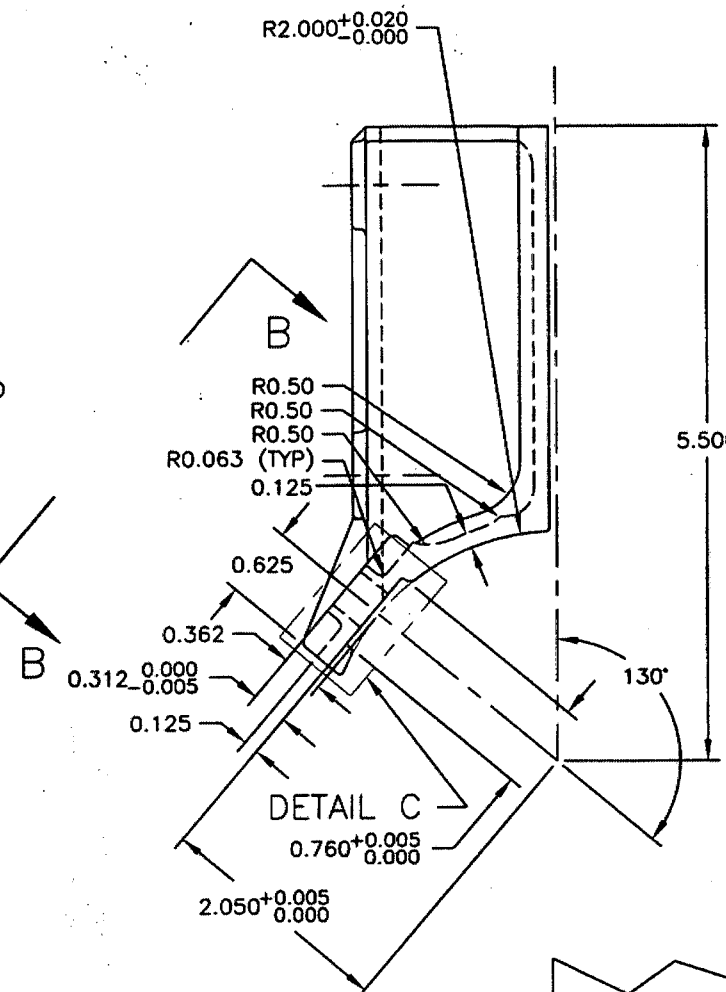


## NOTES

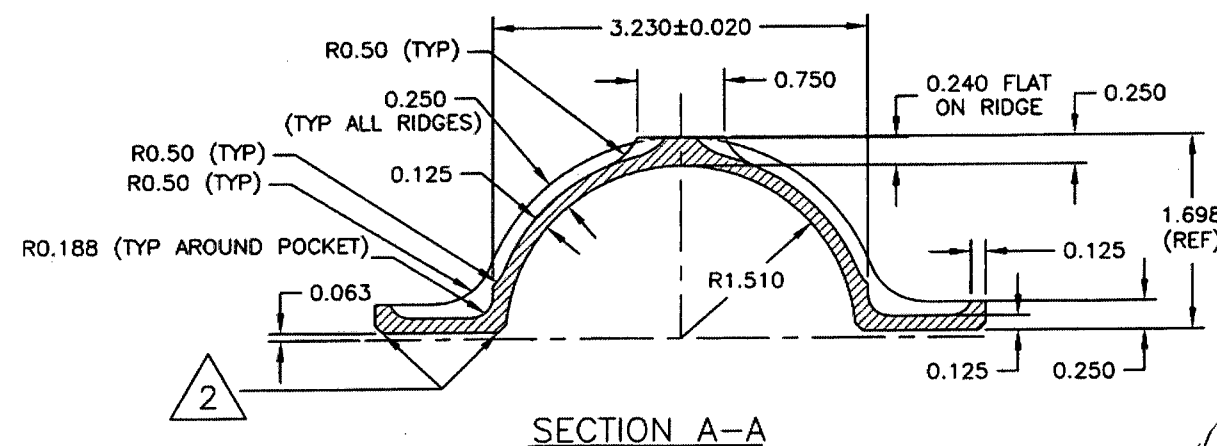
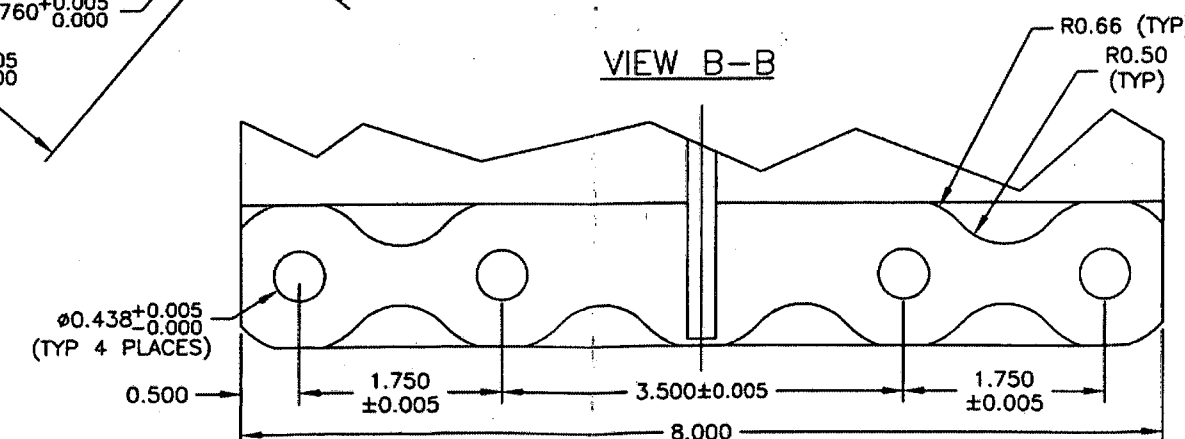
MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010  
2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)  
3 CHAMFER 0.063 x 45° ALL AROUND  
4 CHAMFER 0.033 x 45° (SEE DETAIL C)

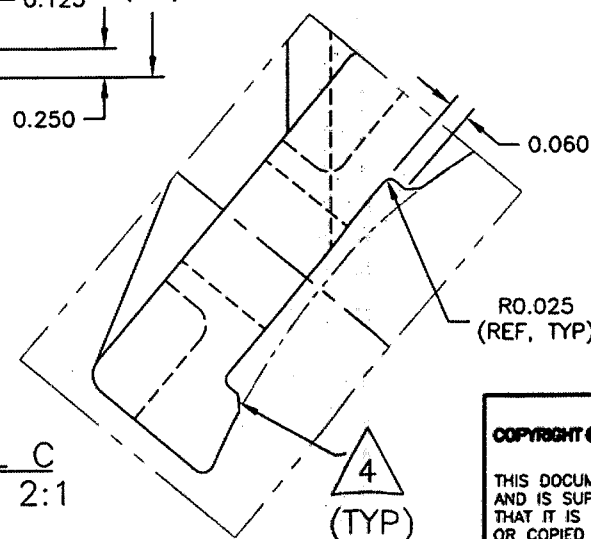
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38058



VIEW B-B



SECTION A-A

DETAIL C  
SCALE 2:1

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OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

|         |          |  |
|---------|----------|--|
| E       | 05.07.13 | ADD CHAMFER ON RIDGE NOTE 4                                |
| D       | 02.09.06 | ADD RIDGES; TIGHTEN TOLERANCES                             |
| C       | 99.10.22 | INCORP. DEO 9123/9079/9102<br>ADD DIMENSIONS PER TSR A1177 |
| B       | 96.12.02 | ADD GRAIN DIR., 0.438 WAS 0.425                            |
| A       | 96.09.16 | NEW ISSUE  |
| DESIGN  | DS       | DRAWN BY PH  |
| CHECKED | PH       | APPROVED PH  |
| DATE    | 05.07.13 | TITLE  |
|         |          | INNER AFT SADDLE   |
|         |          | DART AEROSPACE LTD.<br>HAWKESBURY, ONTARIO, CANADA         |
|         |          | DRAWING NO. D2574  |
|         |          | REV. E   |
|         |          | SHEET 1 OF 1   |
|         |          | SCALE 2:3  |



